

205.633.011

Dart Aerospace Ltd.

Date: Wednesday, 5/16/2007 1:29:06 PM  
User: Kim Johnston

## Process Sheet

22

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	STEP WELDMENT
Job Number	32389A			
Estimate Number	10176			
P.O. Number	N/A		Part Number	D2563
This Issue	5/16/2007	S.O. No. N/A	Drawing Number	D2563 REV C
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type	Drawing Revision	C
Previous Run	32382A	LARGE FAB ASSY	Material	N/A
Written By			Due Date	5/30/2007
Checked & Approved By		2007.05.16	Qty:	10
Comment	Est Rev:G 02.07.31	Re-format Location RF	Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D2244116	Step Extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		Pick:	
	1 D2244 Step Extrusion		
	Batch: 1028216		2007.05.16
2.0	D267334	End Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)	
		Pick:	
	Qty Part No. Description	Batch	
	2 D2673-34 End Cap	332404	
3.0	D2561	Lug Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)	
		Pick:	
	Qty Part No. Description	Batch	
	2 D2561 Lug Plate	330384-16	
4.0	D2564	Mounting Angle	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)	
		Pick:	
	Qty Part No. Description	Batch	
	2 D2564 Mounting Angle	330464	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Shif 06/07 Friday  
Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: STEP WELDMENT	
Job Number: 32389A		Part Number: D2563	
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
5.0	LARGE FAB 1 	LARGE FABRICATION RESOURCE 1 	
Comment: LARGE FABRICATION RESOURCE 1			
1-Cut D2244 to 89.70" at 34° as per Dwg D2563 <i>a.m 07.06.22</i> 10			
2-Deburr ends <i>PL 01.06.25</i> 10			
3-Weld (1 End CAP,LUG PLATES & MOUNTING ANGLE as per Dwg D2563 using DT 8343 A/R AL ROD Batch: <i>M102956</i> <i>M104304</i> <i>PL 07.06.26</i> 10			
4-Grind <i>a.m 07.06.26</i> 10			
6.0	QC5/9 	WELD INSPECTION <i>QC5-207062710</i> 	
Comment: WELD INSPECTION <i>PD 07.06.27</i>			
7.0	HAND FINISHING 	HAND FINISHING RESOURCE #1 	
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>a.m 07.06.28</i> 10			
8.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 	
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <i>PL 07.07.03</i> 10			
9.0	LARGE FAB 1 	LARGE FABRICATION RESOURCE 1 	
Comment: LARGE FABRICATION RESOURCE 1			
1-Inspect for foreign object per QSI 024 <i>PL 07.07.03</i> 10			
2-Weld Remaining End as per Dwg D2563 using DT 8343 A/R AL ROD Batch: <i>M102956</i> <i>M104781</i> <i>PL 07.07.03</i> 10			
10.0	3-Grind <i>a.m 07.07.04</i> QC9 	VISUAL WELDING INSPECTION 	
Comment: VISUAL WELDING INSPECTION <i>PL 07.07.04 (10)</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/07/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
				/	/	/		

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32389A

Part Number: D2563

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC5

INSPECT WORK TO CURRENT STEP



*7/07/04 (10)*



Comment: INSPECT WORK TO CURRENT STEP

12.0 POWDER COATING

POWDER COATING



*(10)*

Comment: POWDER COATING

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*M 107144*

*BR/M 107-07-05*

13.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

*Moffat*

*07/07/05 (10)*

14.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*PPP 32945 7/1/05*



*(10)*

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0 QC21

FINAL INSPECTION/W/O RELEASE



*(8)*

Comment: FINAL INSPECTION/W/O RELEASE

*7/07/05*

Job Completion



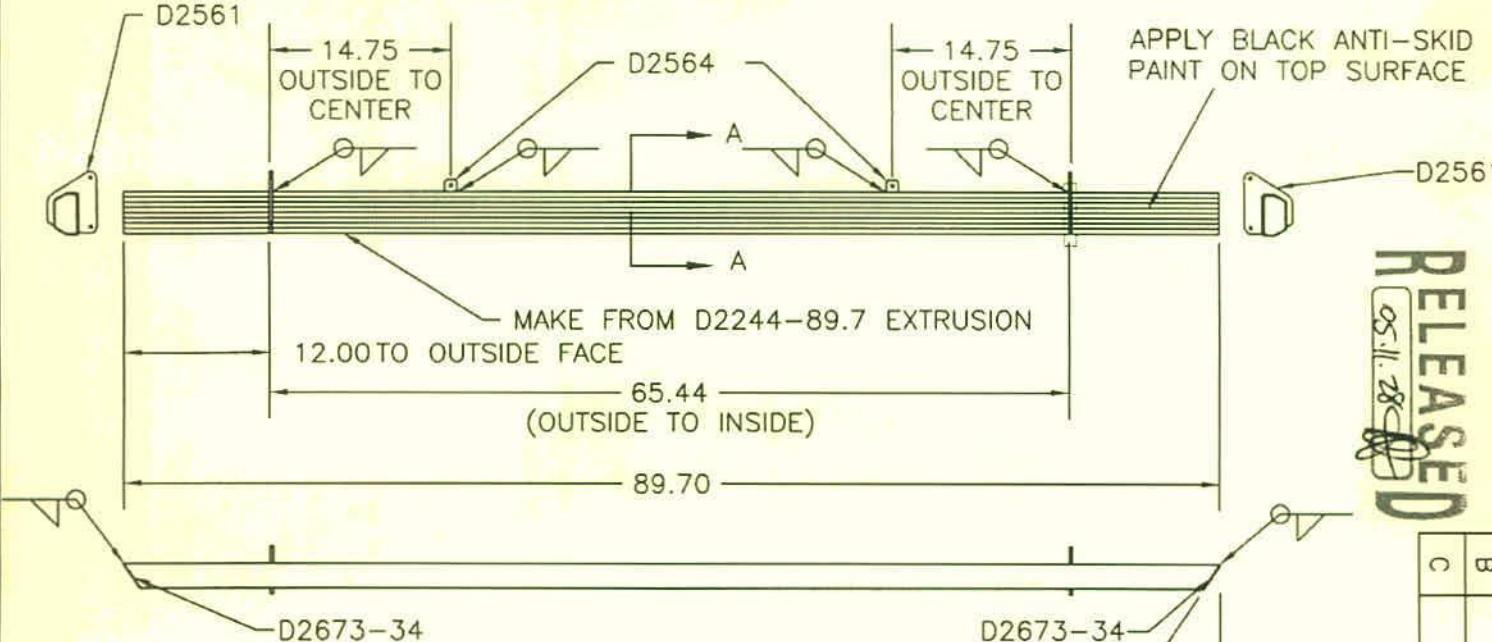
*U 8/07/23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

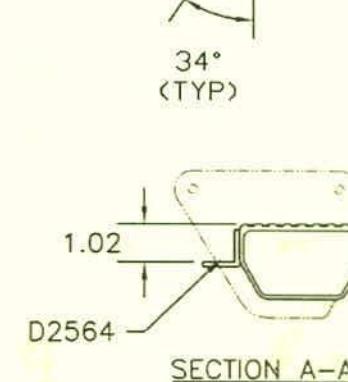


D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

\*Cut per drawing

NO 32389A  
WORK ORDER  
DIRECT TO AMENDMENT  
WITHOUT NOTICE  
CONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY



D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE  
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**DART**  
85-11-28-00

DESIGN BW	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D2563
DATE 05.11.14	TITLE STEP WELDMENT ASSEMBLY	SCALE 1:15
A 05.11.14	96.04.26	NEW ISSUE
B 05.11.14	97.05.14	END CAPS CHANGED (WAS D2248)
C 05.11.14		UPDATE NOTES

REV. C

SHEET 1 OF 1

